

Work Order ID 65485

Tuesday, January 18, 2011 2:43:46 PM



Page 1

Item ID: D3827-041

Accept



Setup Start



Revision ID:

Item Name: Rib Assembly (Inboard)

Stop



Start Date: 1/18/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 1/21/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: mf Date: 11-01-18

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3827

Rev A

100

0.00



Large Fab

Large Fab

Large Fab

Memo

0.00

1- cut D3827-1 rib as per dwg D3827

2- drill holes using DT9435 jig and open to finish size as per dwg D3827

3- c'sink as per dwg

4- remove identification markings

5- deburr

SAD 11-01-19

6- weld bushing in rib as per dwg D3827

A/R S.S. Rod Batch: M114649

7- grind weld flush ✓

8- deburr if necessary ✓

(6x) SY 11/02/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			






NOTE: Date & initial all entries



Work Order ID 65485




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Page 2

Item ID: D3827-041 Accept  Setup Start 
Revision ID: Stop 
Item Name: Rib Assembly (Inboard)
Start Date: 1/18/2011 Start Qty: 6.00  Cust Item ID:
Required Date: 1/21/2011 Req'd Qty: 6.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00		Sulozlos					
140  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		Sulozlos		(16)			
150  Packaging Packaging	Identify as per dwg & Stock Location: <i>WA</i> Memo	0.00 0.00		SAD 11- 02 02-08		(C)			

W/O:		WORK ORDER CHANGES					
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Item ID: D3827-041 Accept  Setup Start 
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Item Name: Rib Assembly (Inboard)
Start Date: 1/18/2011 Start Qty: 6.00  Cust Item ID:
Required Date: 1/21/2011 Req'd Qty: 6.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

u/02/08 
ME
11-02-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, January 18, 2011 2:43:40 PM

Page 1

Work Order ID: 65485

Parent Item: D3827-041

Parent Item Name: Rib Assembly (Inboard)



Start Date: 1/18/2011

Required Date: 1/21/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3759-1		Manufactured	No			100	Each	63.0000	3	18			
Bushing													

Location Loc Qty Loc Code

WA	63	
54072	9	
64421	12	
64843	42	

M304TS0.750W.065		Purchased	No			100	f	505.1260	8	50.52632			
------------------	--	-----------	----	--	--	-----	---	----------	---	----------	--	--	--



304 SQ Tube .75x.75x.065W

Location Loc Qty Loc Code

MAT	505.126	
112398	0	
116267	505.126	

B65709 18x 11/02/07

SAD 11-01-19

50.5264

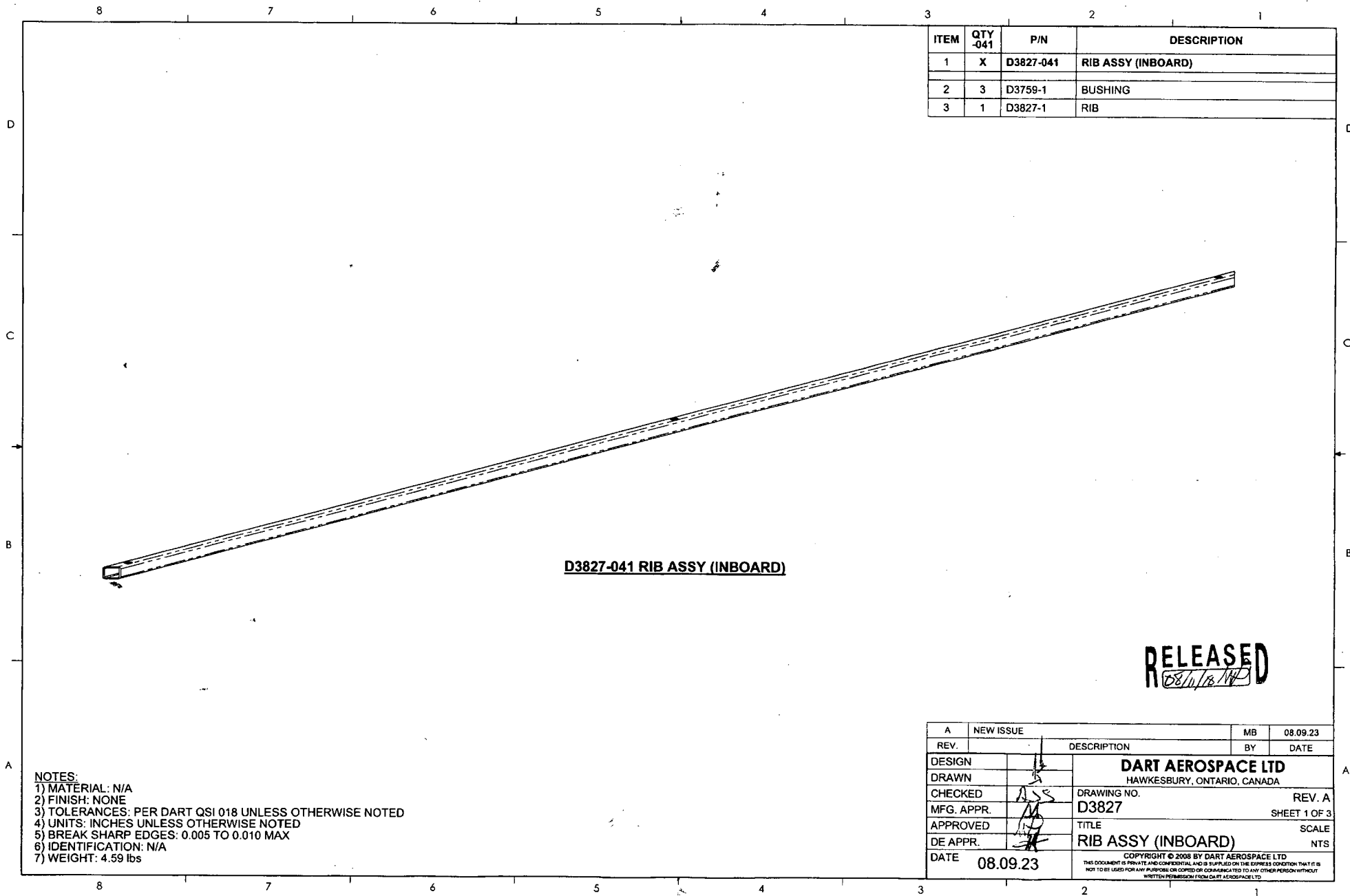
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ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3827-041	RIB ASSY (INBOARD)
2	3	D3759-1	BUSHING
3	1	D3827-1	RIB

D3827-041 RIB ASSY (INBOARD)

RELEASED
08/11/18 MB

- NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 4.59 lbs

A	NEW ISSUE	MB	08.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED	ASS		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.23		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A	
DRAWING NO. D3827		SHEET 1 OF 3	
TITLE RIB ASSY (INBOARD)		SCALE NTS	
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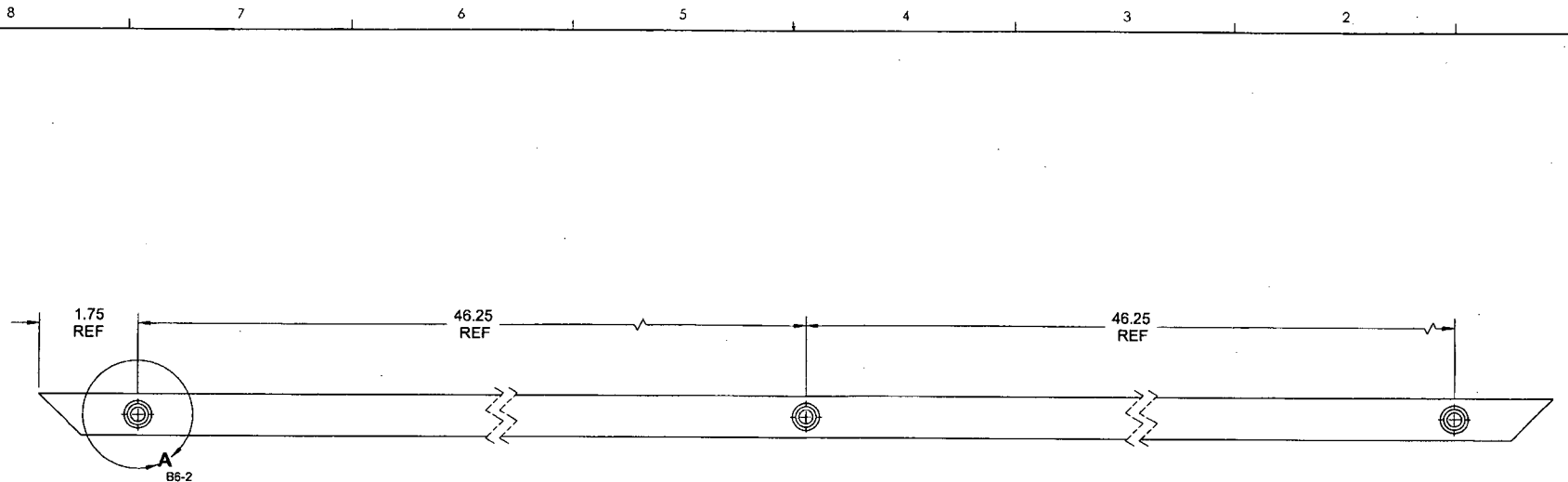
W/O:		WORK ORDER CHANGES					
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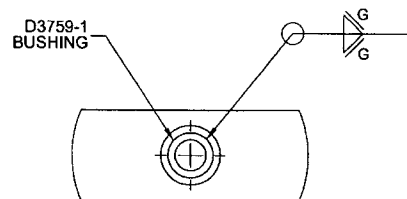
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3827-041 RIB ASSY (INBOARD)



DETAIL A
SCALE 2X
3 PL

RELEASED
08/11/18

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3827	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (INBOARD)	NTS
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NOTE: Date & initial all entries

Ø0.375^{+0.020}
-0.000 THRU
Ø0.49 X 100° CSINK
ON BOTH SIDES
TYP

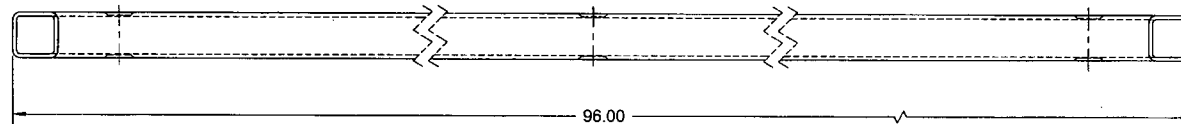
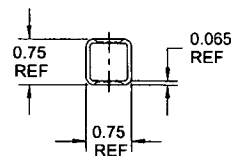
0.375

0.75 X 45° CHAMFER
2 PL

46.250

46.250

1.750



D3827-1 RIB

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 4.55 lbs

RELEASED
08/11/2023

DESIGN		DART AEROSPACE LTD	
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CHECKED		DRAWING NO. D3827	REV. A
MFG. APPR.		SHEET 3 OF 3	
APPROVED		TITLE	SCALE
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